

Date: Thursday, 12/21/2006 12:01:09 PM
 User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: LUG EXTRUSION	
Job Number	: 30062				
Estimate Number	: 10305				
P.O. Number	: N/A		Part Number	: D2423	
This Issue	: 12/21/2006 S.O. No. : N/A		Drawing Number	: D2423 REV B1	
Prsht Rev.	: NC		Project Number	: N/A	
First Issue	: N/A		Drawing Revision	: B1	
Previous Run	: 23779		Material	: N/A	
Written By			Due Date	: 1/2/2007	
Checked & Approved By	: J. A. [Signature]		Qty:	360 Um: Each	
Comment	: Est G 04.09.02 Part Number D2423-108 changed to D2423KJ/J LM				

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	PG	PURCHASING
2.0	D2423P	Lug Extrusion
Comment: Qty.: 1.0000 f(s)/Unit Total : 360.0000 f(s) → 405' Lug Extrusion		
3.0	PACKAGING 1 <i>ensure orders</i>	PACKAGING RESOURCE #1
4.0	QC6	DIMENSIONAL CHECK
5.0	PACKAGING 1 <i>CNC</i>	PACKAGING RESOURCE #1
6.0	QC21	FINAL INSPECTION/W/O RELEASE

Job Completion



U 07.01.18
2016/18

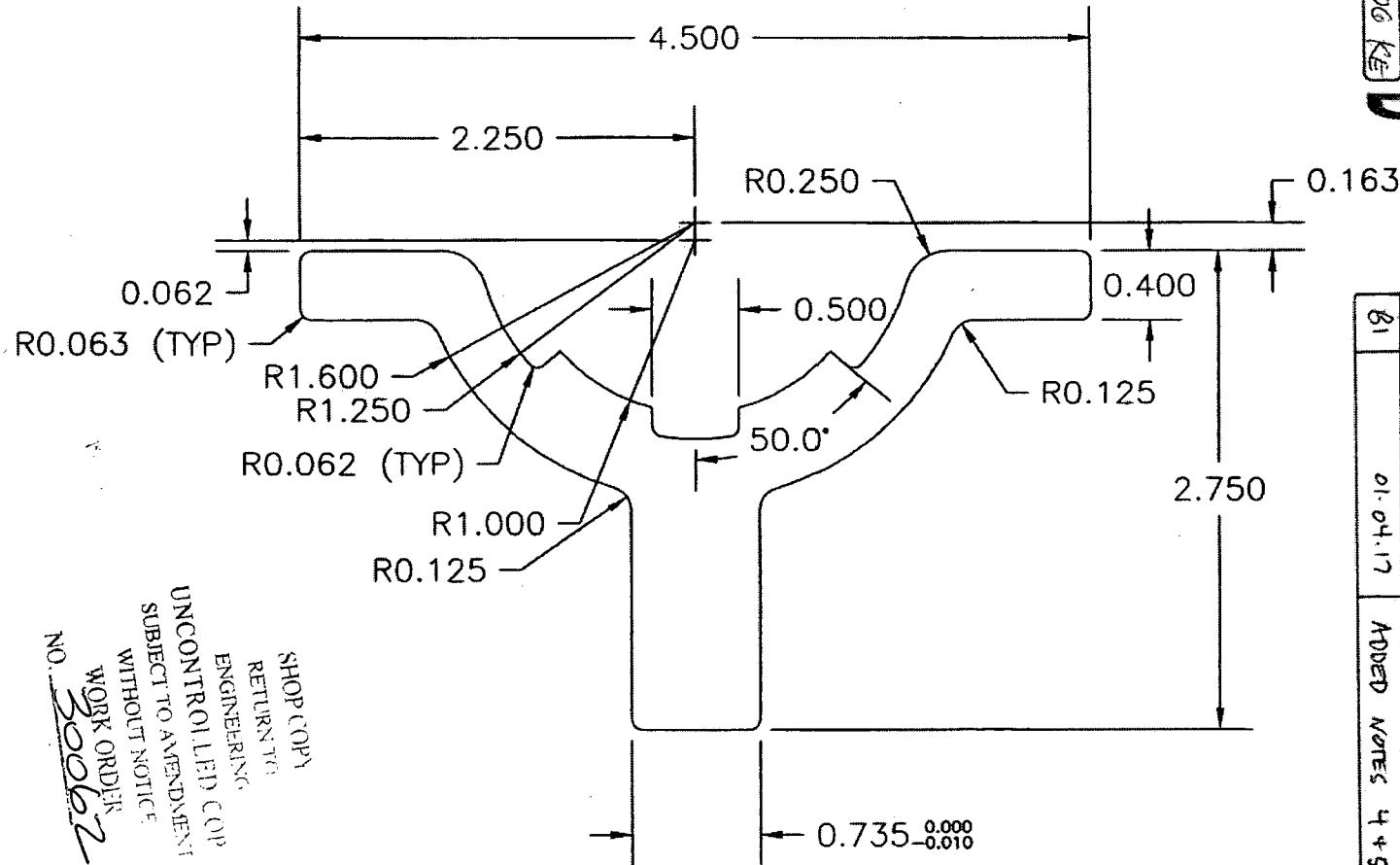
Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: Date: 07/01/18
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



1. MATERIAL: 6061-T6 ALUMINUM (QQ-A-200/8)
2. NOTE: ALL DIMENSIONS ARE IN INCHES
3. TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
4. MANUFACTURED USING CARADON INDALEX DIE # MS-18866
5. PART NUMBER IS D2423-XXX WHERE XXX IS CUT LENGTH IN INCHES (EG. D2423-108 IS 108" LONG)

WORK ORDER
NO. 30062

SHOP COPY
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WITHOUT NOTICE

RELEASED
98/08/06 RE

DART

OF COPY CENTER

DESIGN	DRAWN BY	DART AEROSPACE LTD	
CHECKED	APPROVED	HAWKESBURY, ONTARIO, CANADA	
DATE	REV.	DRAWING NO.	SHEET 1 OF 1
98.08.04	J	D2423	
A	95.05.09	NEW ISSUE	
B	98.08.04	6061-T6 WAS 6005A.T5	
B1	01.04.17	ADDED NOTES 4 & 5 4 CP	

SCALE
1:1



INDALEX LIMITED
325 AVRO Street
POINTE-CLAIREE, QC H9R 5W3
TELEPHONE: (514) 697-5120 & (800) 563-5120
FACSIMILE: (514) 694-8310 & (800) 563-8310

FACSIMILE TRANSMITTAL SHEET

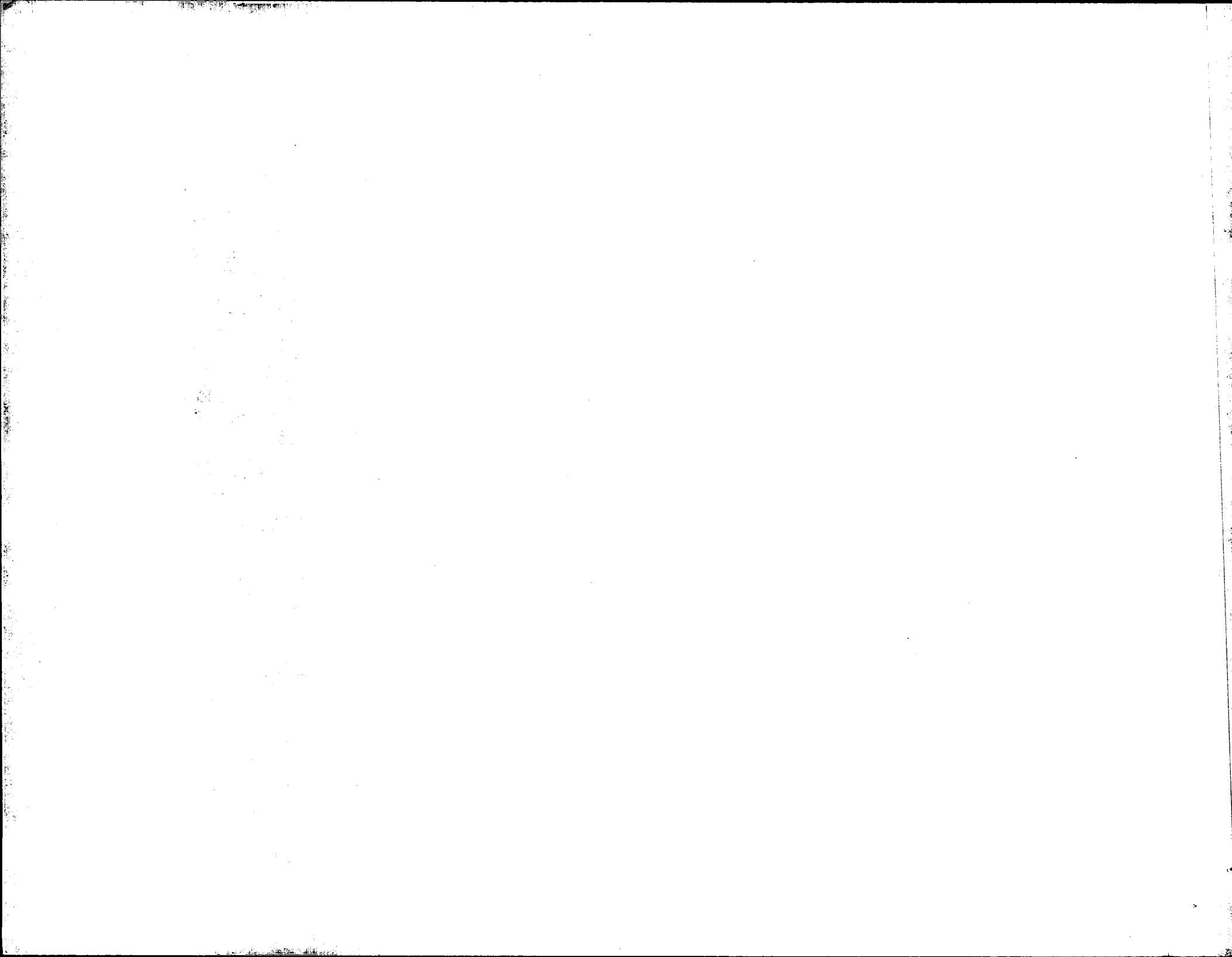
TO:	Christina Young	FROM:	Bruno Morency
			Quality Technician
COMPANY:	DART AEROSPACE LTD	DATE:	2007/01/11
FAX NUMBER:	1(613) 632-4443	TOTAL NO. OF PAGES INCLUDING COVER:	2
PHONE NUMBER:		SENDER'S REFERENCE NUMBER:	
SUBJECT:	REPORT	TIME:	

URGENT FOR REVIEW PLEASE COMMENT PLEASE REPLY PLEASE RECYCLE

NOTES/COMMENTS:

Mechanical properties report

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ALUMINUM SOLUTIONS

325 rue Avro
Pointe-Claire QC H9R 5W5
Téléphone (514) 697-5120
Fax/Simile (514) 694-8310

Rapport des propriétés mécaniques Mechanical Properties Test Report

Client / Customer : DART AEROSPACE LTD

Address / Address : 1270 ABERDEEN STREET

HAWKESBURY ONT,

K6A 1K7

commande Indalex / Indalex order # :

6122430

bon de commande / Purchase order # :

2770

de matrice / Die # : M918888 Description: LUG EXTRUSION

Alliage & tempage / Alloy & temper : 6061 T6

Contrôle / Control # : 36841-1

Coulée / Cast # : 30731

	Min. requis Mn requise	Mn testé	Réultat obtenu Actual results
Tension utile	38 000	49200	49200
Ultimate stress (psi)			
Contrainte d'élasticité	36 000		36076
Yield stress (psi)			
% Elongation dans 2"	8		12.5
% elongation in 2"			
Dureté Rockwell E (moy)	88 à 100		98
Rockwell E Hardness (moy)			

Composition chimique typique / Typical chemical composition :

	Si	Fe	Cu	Mn	Mg	Cr	Zn	Ti
3063	0.20 - 0.40	0.35 Max	0.10 Max	0.10 Max	0.45 - 0.90	0.10 Max	0.10 Max	0.10 Max
3005	0.40 - 0.50	0.35 Max	0.10 Max	0.10 Max	0.40 - 0.60	0.10 Max	0.10 Max	0.10 Max
3061	0.68 - 0.72	0.15 - 0.27	0.08 - 0.12	0.20 - 0.34	0.48 - 0.52	0.03 Max	0.05 Max	0.03 Max
3061	0.40 - 0.60	0.70 Max	0.15 - 0.40	0.15 Max	0.80 - 1.20	0.04 - 0.35	0.25 Max	0.16 Max
3061	0.7 - 1.3	0.5 Max	0.10 Max	0.40 - 0.80	0.40 - 0.40	-	0.20 Max	0.20 Max

Nous certifions que le matériel fourni rencontre les exigences chimiques telles qu'annoncées par la norme ASTM B-221 et AMS QQA 2008 ainsi que les exigences de nos procédures de contrôle de qualité.

We hereby certify that the material supplied meets the chemical properties as published by the ASTM B-221 and AMS QQA 2008 standard and requirements of our quality control procedures.

Sincèrement vôtre,

Date : 2007-01-11

Yours truly,

Bruno Voyer,
Technician de la qualité
Quality technician

Ltd/Inc Limited